

Work Order ID 84597

May-16-12 3:32:01 PM

84597

Page 1

Item ID: D3913-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long Basket Base Assembly, 350

Start Date: 16/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	A								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: 1118161 0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A

inspect before welding mesh

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D3913

take lid to locate hinge and bracket

(1x)

12.05.30

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

1x 12.05.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84597

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May-16-12 3:32:01 PM

Item ID: D3913-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Base Assembly, 350
 Start Date: 16/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 30/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

1 7/16 12-5-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 84597

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Item ID: D3913-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Base Assembly, 350
 Start Date: 16/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 30/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat 1ST COAT: <u>7-45</u> START TIME: <u>4000F</u> OVEN TEMPERATURE: <u>8-45</u> FINISH TIME: <u>8-45</u> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				X	Ø		<u>M-L</u> <u>12/06/01</u>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>1</u>	<u>Ø</u>	<u>BL 12-6-1</u>	

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 16/05/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 30/05/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

Assemble as per dwg

0.00

150

0.00

HandFinish

Memo

Hand Finishing

Pick Kit

QC5- Inspect part completeness to step on W/O

0.00

160

0.00

QC

Memo

Quality Control

Identify as per dwg & Stock Location: 10540-0460

460

170

0.00

Packaging

Memo

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3913-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop *NS2*

Start Date: 16/05/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 30/05/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MCJ 12 | 06 | 05

MLJ 12/06/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 84597

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581		Manufactured	No			100	Each	64.0000	2	2			
D2581									**				
Mounting Bracket													

Location	Loc Qty	Loc Code
WA	2	
82506	2	
WA005	62	
70766	2	
81253	1	
82017	19	
82897	40	

D3913-1		Manufactured	No			100	Each	3.0000	1	1			
D3913-1									**				
Rib													

Location	Loc Qty	Loc Code
WA	3	
74145	0	
80790	1	
83226	2	

D3913-15		Manufactured	No			100	Each	13.0000	1	1			
D3913-15									**				
Wide Handle Plate													

Location	Loc Qty	Loc Code
WA	1	
81440	1	
WA005	12	
82919	12	

B83230 → 2x 12.05.28

B82918 → 1x 12.05.28

12.05.28

1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-3

Manufactured No

100

Each

7.0000

1

1

D3913-3

Rib

**

B84651 → 1x 12.05.28

Location

Loc Qty

Loc Code

WA

6

69160

0

74144

0

82920

6

WA006

1

69160

1

D3913-7

Manufactured No

100

Each

11.0000

2

2

D3913-7

Rib

**

12.05.28

Location

Loc Qty

Loc Code

WA

6

83908

6

WA006

5

82922

1

84597

4

D3913-9

Manufactured No

100

Each

5.0000

1

1

D3913-9

Hinge Rib

**

12.05.28

Location

Loc Qty

Loc Code

WA

4

81200

4

WA006

1

70138

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 84597

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3916-041

Manufactured No

100

Each

6.0000

2

2

D3916-041

Rib Assembly

**

SL 12.05.28

Location

Loc Qty

Loc Code

WA006

6

81444

2

82931

4

2x

D3916-5

Manufactured No

100

Each

11.0000

3

3

D3916-5

Light Rib

**

SL 12.05.28

Location

Loc Qty

Loc Code

WA

11

77142

1

82935

10

3x

D4016-1

Manufactured No

100

Each

2.0000

3

3

D4016-1

Hinge Half, Base

**

B84049 → 3x SL 12.05.28
B84

Location

Loc Qty

Loc Code

WA

2

66418

0

82709

2

D4017-7

Manufactured No

100

Each

11.0000

1

1

D4017-7

Rib

**

B80827 → 1x SL 12.05.28

Location

Loc Qty

Loc Code

WA

10

82969

10

WA005

1

69730

1

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Shop Packet Print

Page 3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84597

84597

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

D4017-9

Manufactured No

100

Each

17.0000

2

2

D4017-9

Rib

**

12.05.28

Location

Loc Qty

Loc Code

WA

5

81445

5

WA006

12

70341

2

73531

4

83228

6

100

Each

4.0000

2

2

D4020-11

Manufactured No

D4020-11

End Mesh, Basket

**

B83799 12.05.31

Location

Loc Qty

Loc Code

WA

-10

81442

2

WA035

14

82971

2

100

Each

24.0000

3

3

D4021-1

Manufactured No

D4021-1

Handle Plate

**

12.05.28

Location

Loc Qty

Loc Code

WA

12

69518

0

74316

0

74946

0

84050

12

WA005

12

82973

12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 84597

84597

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

D4034-041

Manufactured No

100

Each

5.0000

1

1

D4034-041

Aft Upper Rib Assembly

**

12.05.28

Location

Loc Qty

Loc Code

WA

5

78328

5

D4034-043

Manufactured No

100

Each

2.0000

1

1

D4034-043

Fwd Upper Rib Assembly

**

BB3756 7/14

12.05.28

Location

Loc Qty

Loc Code

WA006

2

81431

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 84597

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

995.0738

33

33

M304EX0 75-16F

Expanded Metal Flat SS

**

M/21849 → 33 SH 12-05-31

Location

Loc Qty

Loc Code

MAT

48.8585

121347

48.8585

WA

450.4569156

119180

0.0001156

121471

130.4568

121738

320

WA035

495.7583481

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

12.3232686

120153

2.97557478

120917

120.52013

121082

14.14

121521

0.690084

AN3-10A

Purchased

No

150

Each

215.0000

6

6

✓

AN3-10A

Bolt

**

JB 12/06/01

Location

Loc Qty

Loc Code

GA

12

119084

12

ST351

203

117795

2

120873

201

120873

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832 Purchased No

150

Each

0.0000

2

2

✓

AN960JD8

Washer

D2931

Manufactured No

150

Each

428.0000

2

2

✓

D2931

Bumper

**

120122 JB

**

JB

Location

Loc Qty

Loc Code

ST504

428

46064

428

46064

D4021-5

Manufactured No

150

Each

6.0000

2

2

✓

D4021-5

Blanking Plate

**

JB

Location

Loc Qty

Loc Code

ST084

6

82974

6

82974

MS20600-AD4W3

Purchased No

150

Each

904.0000

2

2

✓

MS20600-AD4W3

Cherry Rivets

**

JB 12/04/01

Location

Loc Qty

Loc Code

ST321

771

111636

36

117601

3

118626

474

120308

258

118626

WA018

133

107939

133

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

2,596.000

6

6

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

2596

117885

32

119017

1114

119075

138

121349

379

121444

933

121349

NAS1149F0332P

Purchased

No

150

Each

524.0000

12

12

**

NAS1149F0332P

WASHER

Location

Loc Qty

Loc Code

ST275

524

117735

13

119225

10

120986

200

121259

200

121584

50

121585

48

17317

3

121825

JB

12/06/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

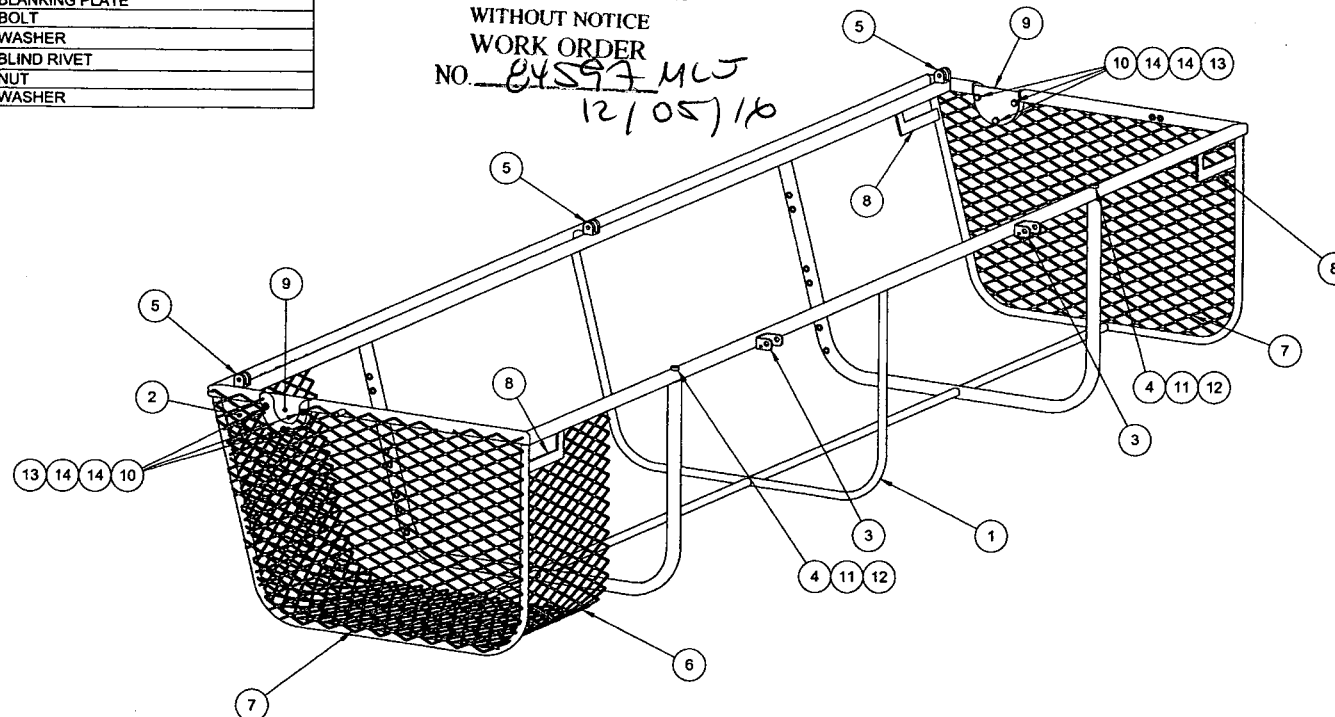
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 84597 MLJ
12/05/16



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

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2010-03-22
JPH

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
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MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A
SHEET 1 OF 6

TITLE **LONG BASKET BASE ASSY (350) NTS**
SCALE

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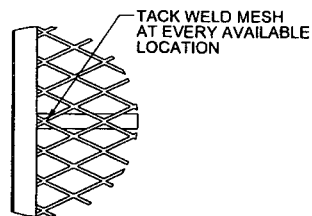
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

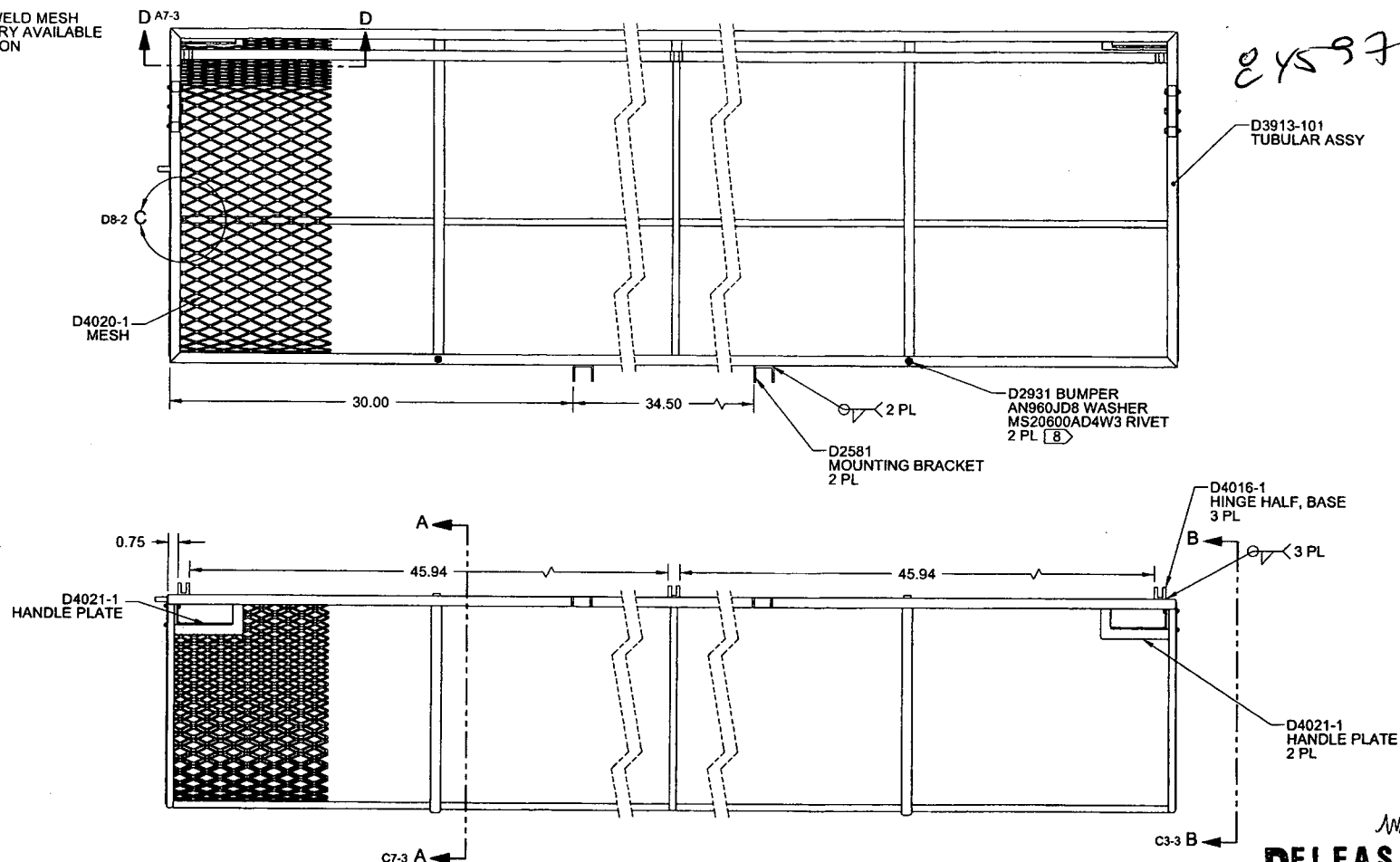
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

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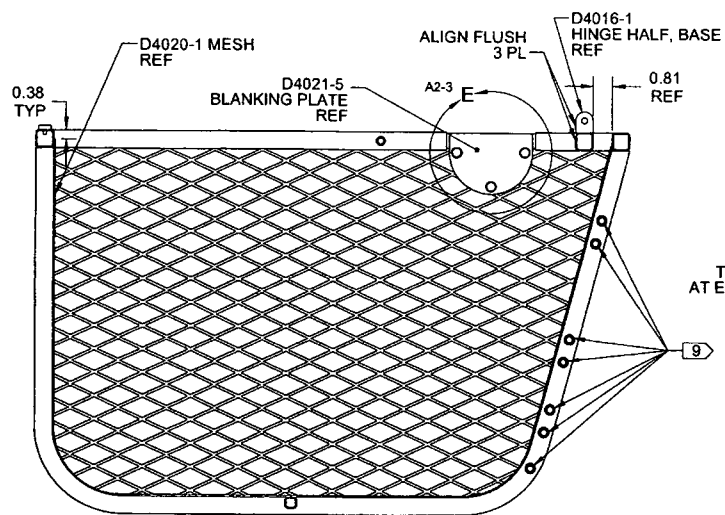
Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

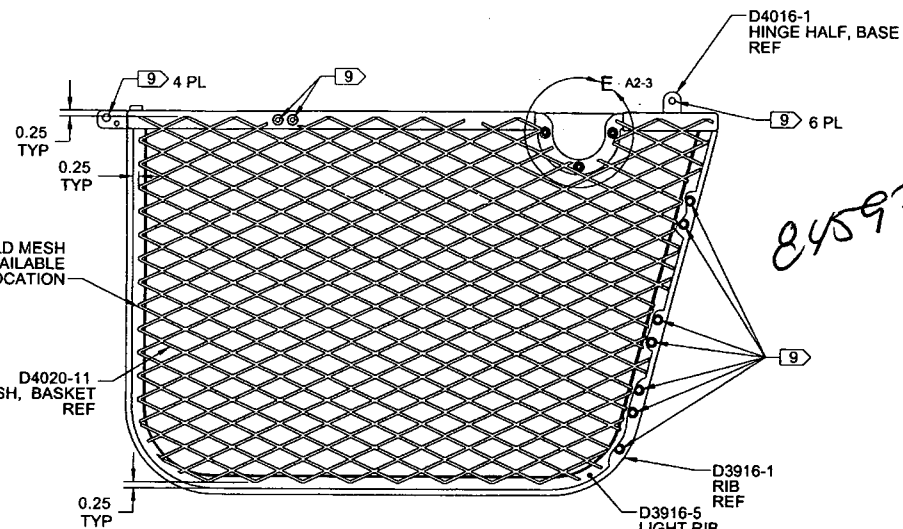
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

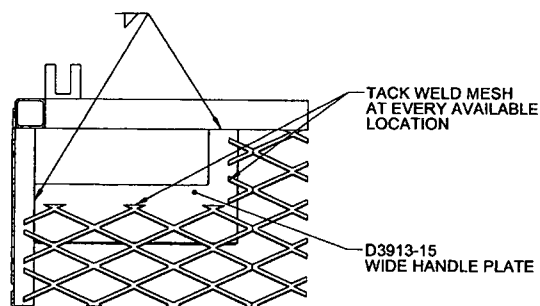
NOTE: Date & initial all entries



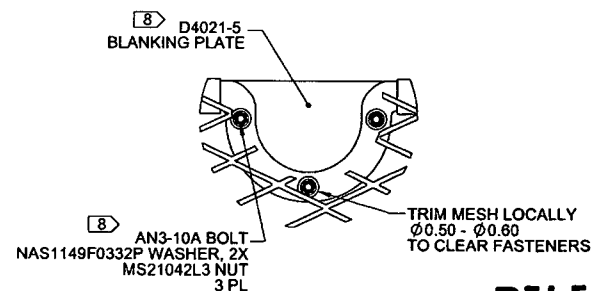
SECTION A-A A5-2







VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL D2-3
D6-3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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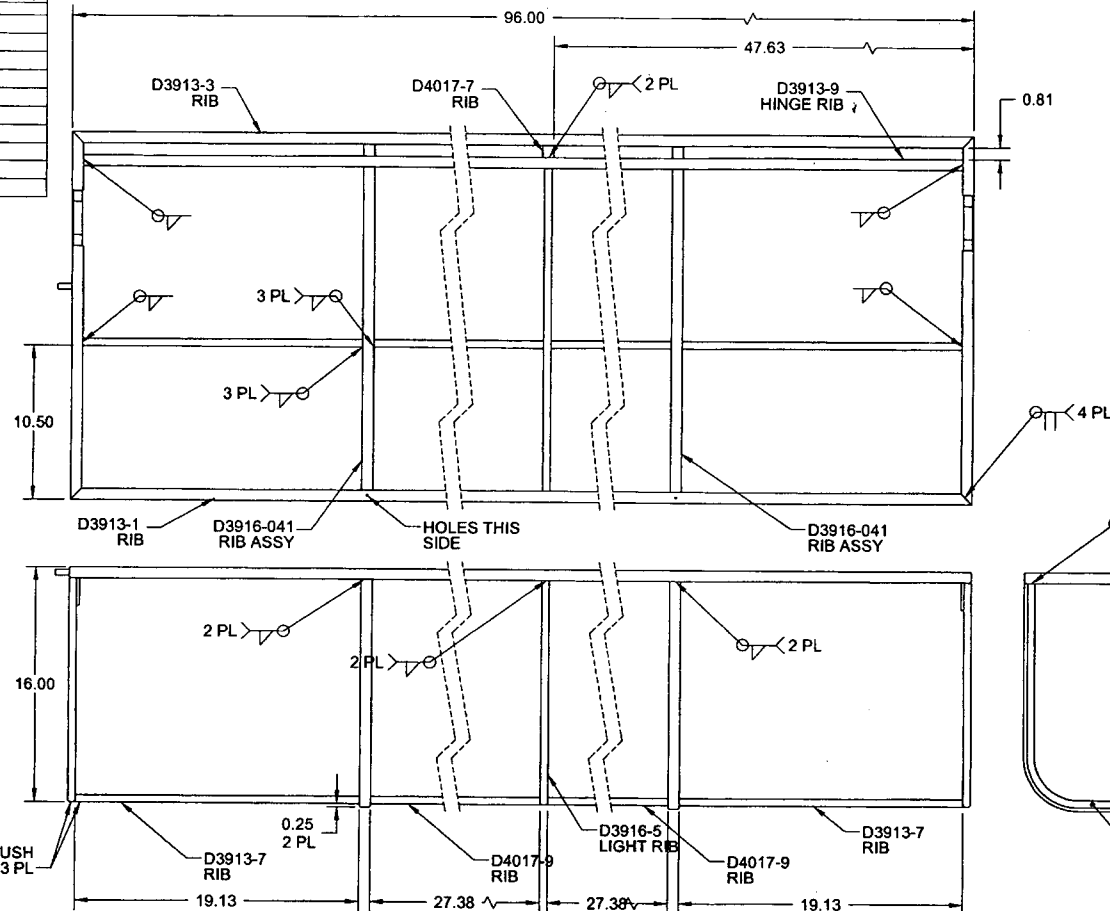
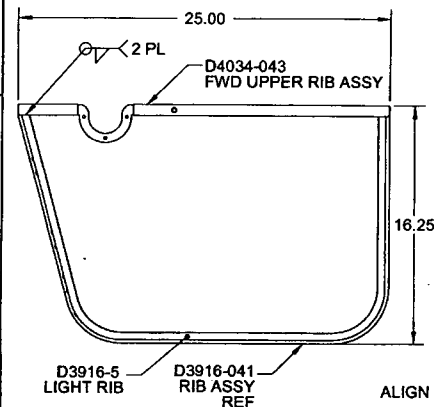
ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY

D

C

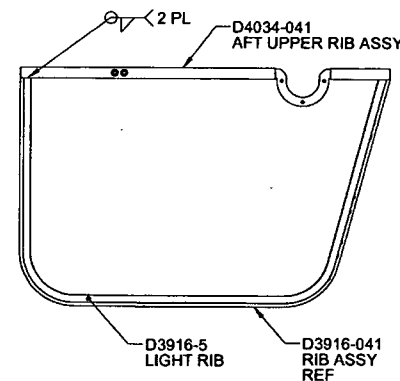
B

A



24597

8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

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2010-03-22

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
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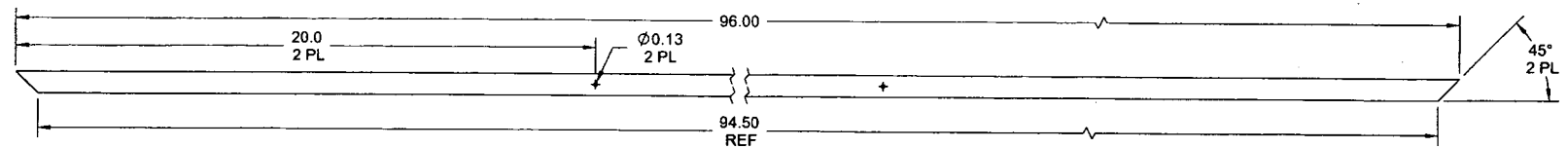
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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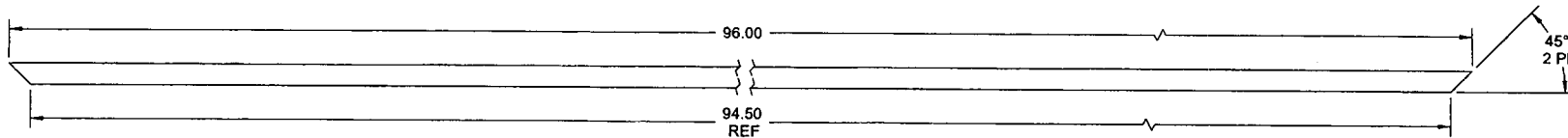
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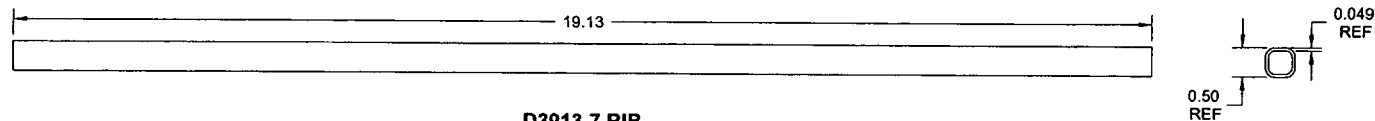


D3913-1 RIB

84597



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

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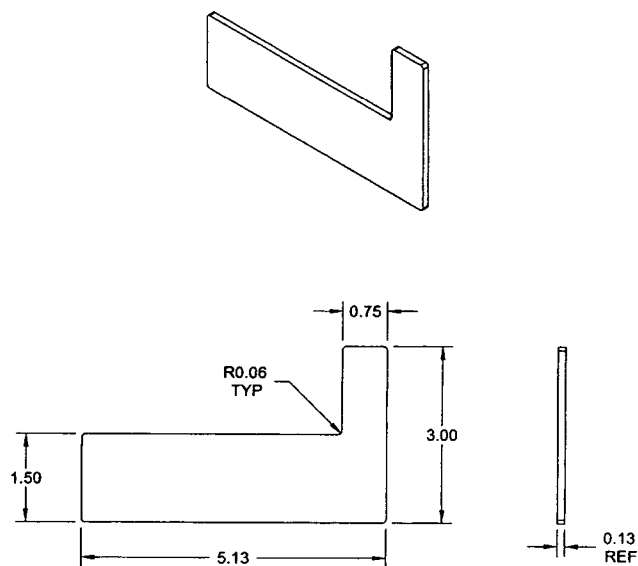
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3913	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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04597

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

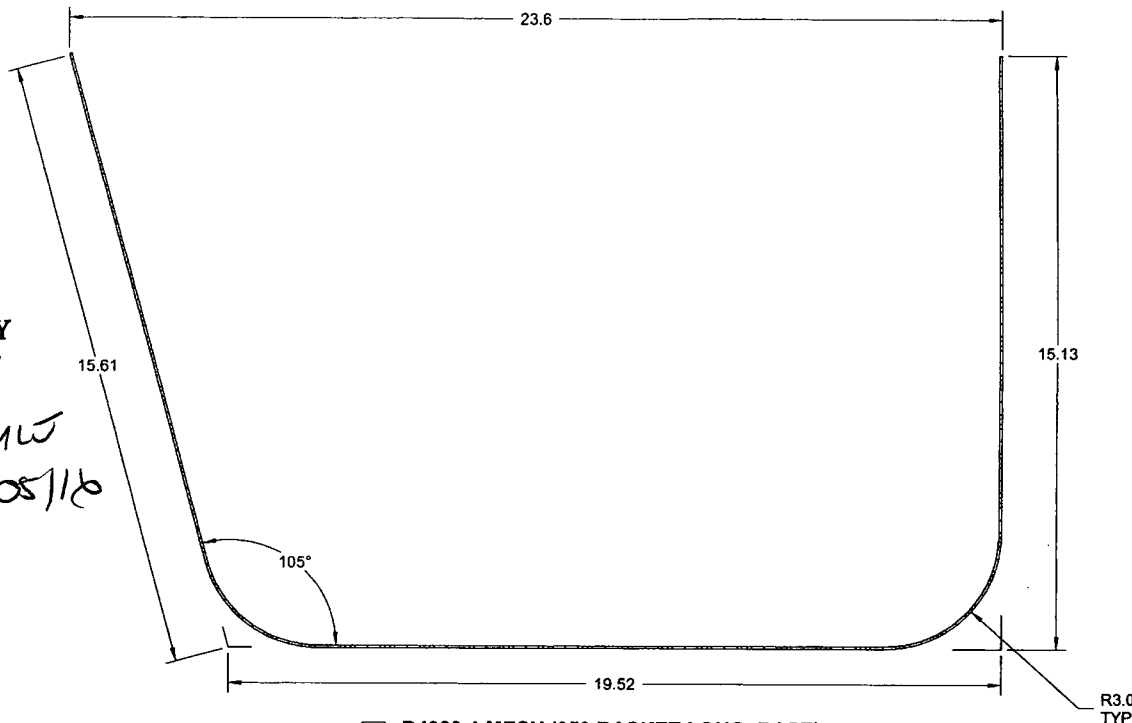
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 WITHOUT NOTICE
 WORK ORDER
 NO. 84557 MLW
 12/05/10



9 D4020-1 MESH (350 BASKET LONG, BASE)
 (SEE D4020-1F FOR LENGTH)

9 D4020-3 (350 BASKET SHORT, BASE)
 (SEE D4020-3F FOR LENGTH)

RELEASED
 2010-03-12

NOTES:

- 1) MATERIAL-1: MAKE FROM D4020-1F
 -3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4020	SHEET 1 OF 4
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DE APPR.	JPH	350 BASKET MESH (BASE)	NTS
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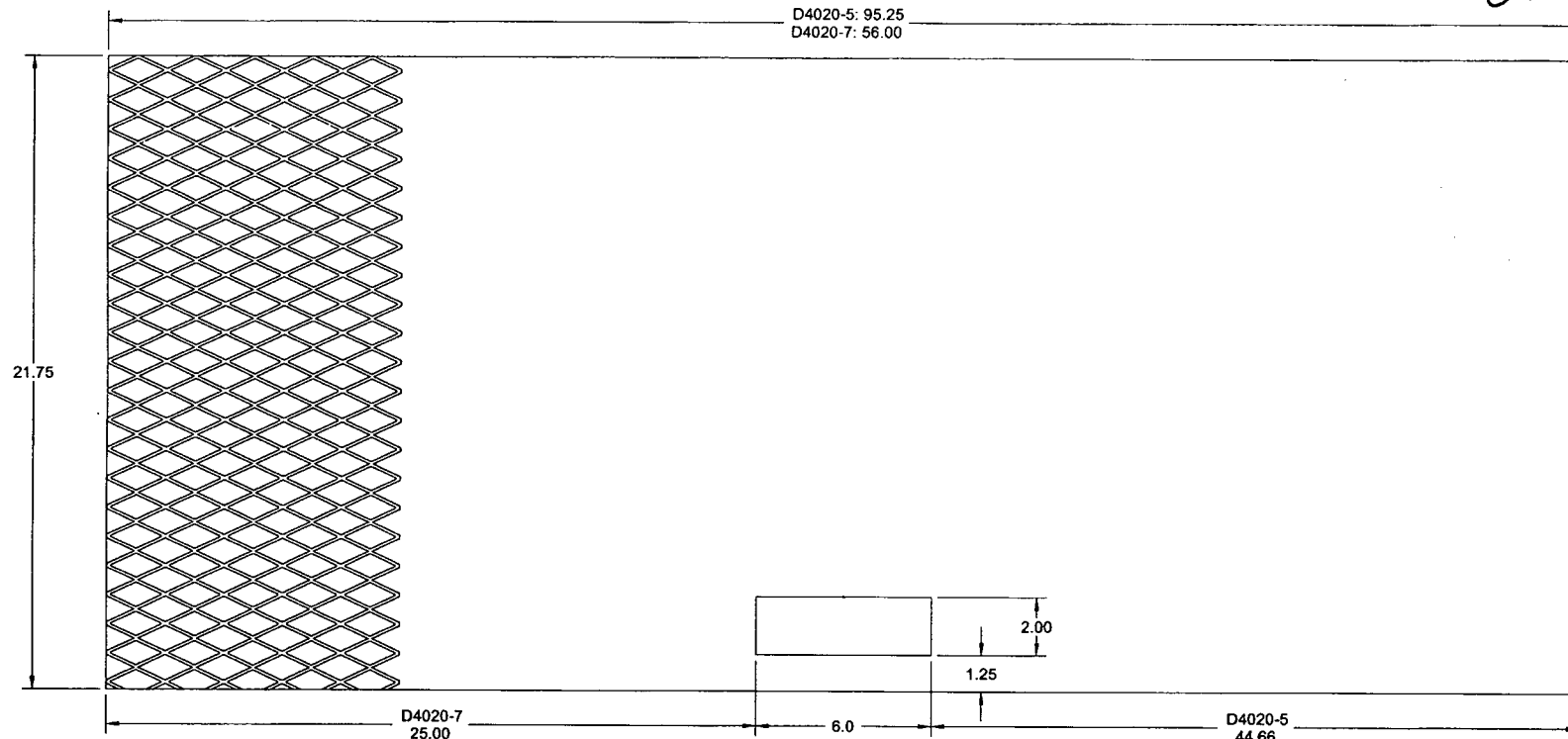
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

04597



9 D4020-5 MESH (350 BASKET LONG, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9 D4020-7 MESH (350 BASKET SHORT, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

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2010-03-12
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MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
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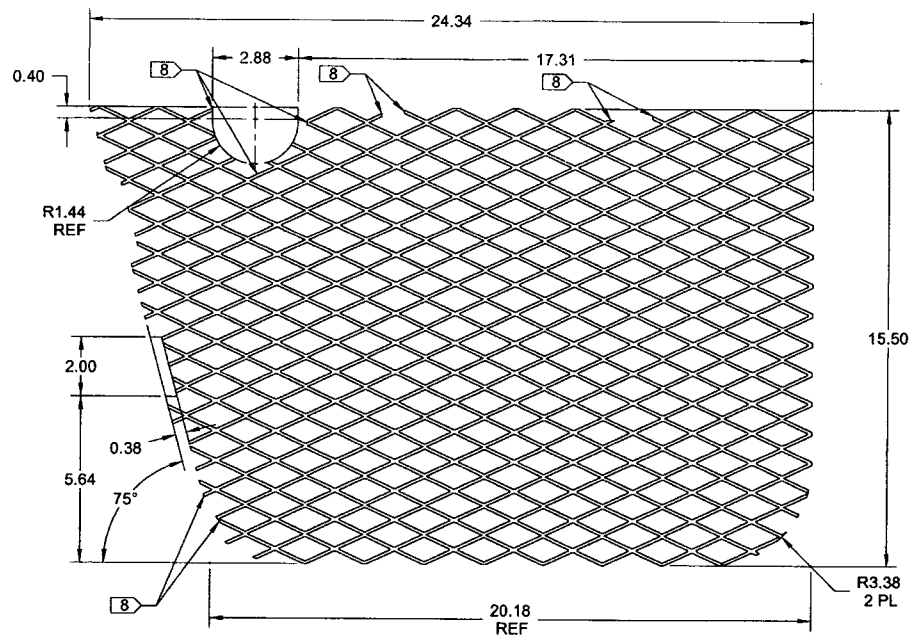
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



9) **D4020-11 END MESH, BASKET**

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

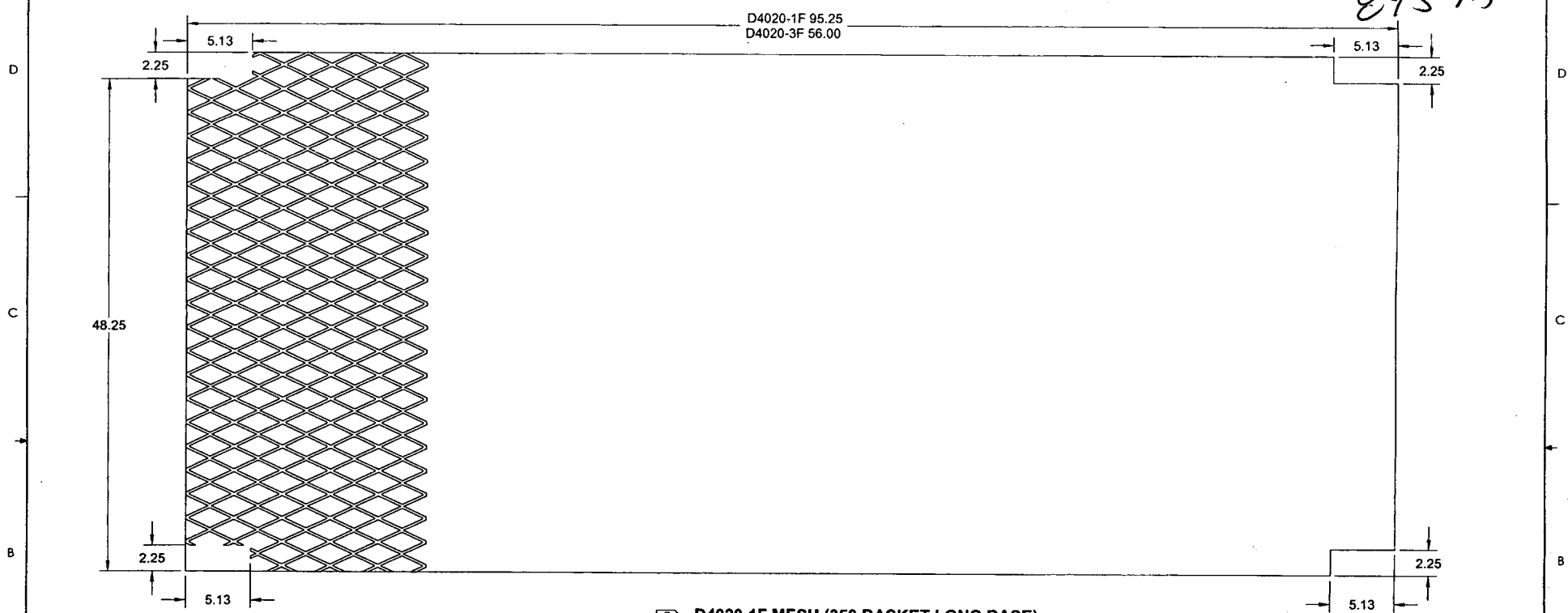
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84597



- 8) **D4020-1F MESH (350 BASKET LONG BASE)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)
- 8) **D4020-3F MESH (350 BASKET SHORT, BASE)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010-03-13
JW

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1F: 17.33 lbs APPROX
-3F: 10.16 lbs APPROX
- 8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	
DATE	10.03.04	NTS	

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